

Date: Wednesday, 07/01/2009 1:52:10 PM
User: Julie Dawson

Process Sheet

20/09/09

Customer : CU-DAR001 Dart Helicopters Services Job Number : 44424 Estimate Number : 13253 P.O. Number : This Issue : 07/01/2009 S.O. No. : Prsht Rev. : NC First Issue : 07/01/2009 Type : MACHINED PARTS Previous Run : 44427 Written By : Checked & Approved By : <u>JW 09.01.09</u> Comment : Est Rev:A new issue ECN1165p 08-03-31 DD verified by:EC	Drawing Name : REPLACEMENT ENGINE MOUNT KIT Part Number : D205770011 Drawing Number : IIN205-770 REV A Project Number : N/A Drawing Revision : A Material : Due Date : 30/01/2009 Qty: 1 Um: Each
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Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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for 09/01/28



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D205-770-011 CHG001

5 09/01/28

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D3684043	MOUNT ASSEMBLY
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

MOUNT ASSEMBLY

batch: B45215

CMK 09-01-28

4.0	D3684045	INBOARD LEG ASSEMBLY
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

LEG ASSEMBLY

batch: B45218

CMK 09-01-28

5.0	D36921	SPACER
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SPACER

batch: B44689

SS 09/01/28

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 07/01/2009 1:52:10 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT ENGINE MOUNT KIT

Job Number: 44424

Part Number: D205770011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN3C12A

Bolts



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolts

batch: M 110584

JS 09/01/28 (X)

7.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M110023

JS 09/01/28 (X)

8.0

D3685041

BIPOD MOUNT ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BIPOD MOUNT ASSEMBLY

batch: B45216

MF 09-01-28

9.0

D3686041

MONOPOD ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

MONOPOD ASSEMBLY

batch: B45217

MF 09-01-28

10.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

09/01/28 (1)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-770-011 CHG001

Location: _____

PPP Rev: _____

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/28

Job Completion



MF 09-01-28

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4. WEIGHT AND BALANCE

The following is the net weight increase associated with the D205-770-011 Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-770-011	14.6 lb	-3.5 in	-51.1 in-lb	107.8 in	1574 in-lb
Replacement Engine Mount Kit	6.62 kg	-0.09 m	-0.6 m-kg	2.74 m	18.1 m-kg

5. PARTS LIST

Qty -011	Part Number	Description
X	D205-770-011	REPLACEMENT ENGINE MOUNT KIT
1	D3684-041	TRIPOD MOUNT ASSEMBLY
1	*D3684-043	MOUNT ASSEMBLY
8	**D3692-1	SPACER
4	**AN3C-12A	BOLT
4	**MS21043-3	NUT
1	**D3687-1	MOUNT
1	**D3684-047	FWD LEG ASSEMBLY
1	***D3688-1	STUD
1	***D3689-1	SLEEVE
1	***D3691-1	STUD
4	***D3692-1	SPACER
1	***D3693-1	ROD END BEARING
2	***AN3C-12A	BOLT
2	***MS21043-3	NUT
1	***NAS509-12C	NUT
1	***NAS509L-12C	NUT
1	**D3684-049	AFT LEG ASSEMBLY
1	***D3688-3	STUD
1	***D3689-1	SLEEVE
1	***D3691-1	STUD
4	***D3692-1	SPACER
1	***D3693-1	ROD END BEARING
2	***AN3C-12A	BOLT
2	***MS21043-3	NUT
1	***NAS509-12C	NUT
1	***NAS509L-12C	NUT
1	*D3684-045	INBOARD LEG ASSEMBLY
1	**D3688-5	STUD
1	**D3689-1	SLEEVE
1	**D3691-1	STUD
4	**D3692-1	SPACER
1	**D3693-1	ROD END BEARING
2	**AN3C-12A	BOLT
2	**MS21043-3	NUT
1	**NAS509-12C	NUT
1	**NAS509L-12C	NUT
4	*D3692-1	SPACER
2	*AN3C-12A	BOLT
2	*MS21043-3	NUT

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Revision: A

Date: 08.11.01

---	1	D3685-041	BIPOD MOUNT ASSEMBLY
	1	*D3687-3	MOUNT
	1	*D3684-047	FWD LEG ASSEMBLY
	1	**D3688-1	STUD
	1	**D3689-1	SLEEVE
	1	**D3691-1	STUD
	4	**D3692-1	SPACER
	1	**D3693-1	ROD END BEARING
	2	**AN3C-12A	BOLT
	2	**MS21043-3	NUT
	1	**NAS509-12C	NUT
	1	**NAS509L-12C	NUT
	1	*D3684-049	AFT LEG ASSEMBLY
	1	**D3688-3	STUD
	1	**D3689-1	SLEEVE
	1	**D3691-1	STUD
	4	**D3692-1	SPACER
	1	**D3693-1	ROD END BEARING
	2	**AN3C-12A	BOLT
	2	**MS21043-3	NUT
	1	**NAS509-12C	NUT
	1	**NAS509L-12C	NUT
	8	*D3692-1	SPACER
	4	*AN3C-12A	BOLT
	4	*MS21043-3	NUT
	1	D3686-041	MONOPOD ASSEMBLY
	1	*D3688-7	STUD
	1	*D3689-1	SLEEVE
	1	*D3691-1	STUD
	4	*D3692-1	SPACER
	4	*D3692-3	SPACER
	1	*D3693-1	ROD END BEARING
	1	*D3693-3	ROD END BEARING
	2	*AN3C-10A	BOLT
	2	*AN3C-12A	BOLT
	4	*MS21043-3	NUT
	1	*NAS509-12C	NUT
	1	*NAS509L-12C	NUT

(NOTE: PARTS IN BOLD TYPE CONSTITUTE PICK LIST FOR D205-770-011 KIT)

* PART IS INCLUDED WITH ASSEMBLY ABOVE

** PART IS INCLUDED WITH ASSEMBLY ABOVE

*** PART IS INCLUDED WITH ASSEMBLY ABOVE

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